

Work Order ID 77686 - 1 Split - 1

77686

Page 1

Friday, December 16, 2011 12:48:18 PM

Item ID: D3405-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 12/16/2011 Start Qty: 11.00

11

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date: 1/12/16 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3405

Rev B

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B11-12-29

(15)

B11-12-29

S 11/12/29

(415)

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld as per Dwg D3405 use DT8484 Identify as D3405-041								

SB 12/16/09

Sizeladog

10

A 12-1-23

x10

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Page 3

Item ID: D3405-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 12/16/2011 Start Qty: 11.00 ***11*** Cust Item ID:
 Required Date: 1/6/2012 Req'd Qty: 11.00 ***11*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC9- Inspect visual per QSI004- Fusion Welds 0.00

160

QC

Quality Control

Memo

0.00

Pl 12.01.24

10x

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC

Quality Control

Memo

0.00

S 12/16/24

(40)

180 White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel 0.00

180

Powdercoat

Powder Coating

Memo

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

*1:00
400°F
1:30*

0.00

10x M-12/16/25

m 119480

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Friday, December 16, 2011 12:48:18 PM

Item ID: D3405-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 12/16/2011 Start Qty: 11.00

11

Cust Item ID:

Required Date: 1/6/2012 Req'd Qty: 11.00

11

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190 QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

10x d M 12/01/25
counted & identified

200

Identify as per dwg & Stock Location: ST 478 0.00

200

Packaging

Memo

0.00

Packaging

(10x) SP 12-01-25

210

QC21- Final Inspection - Work Order Release 0.00

210

QC

Memo

0.00

Quality Control

12/11/26

12-01-26
(10)

Picklist Print

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Page 1

Work Order ID: 77686

77686

Parent Item: D3405-041

D3405-041

Parent Item Name: Lug Assembly

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 11.00

Required Qty: 11.00

Comments:

IPP A05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1

Manufactured

No

100

Each

57.0000

J

11

D3404-1

**

12-1-23

GHW Lug

Location

Loc Qty

Loc Code

WA030

57

70664

7

72326

5

74551

5

76994

40

M304S11GA

Purchased

No

150

sf

61.9000

0.154

1.783158

25.

M304S11GA

**

12-12-29

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

61.9

119006

32.5

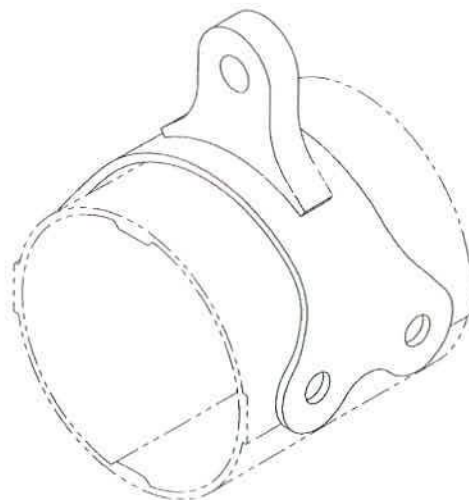
119048

29.4

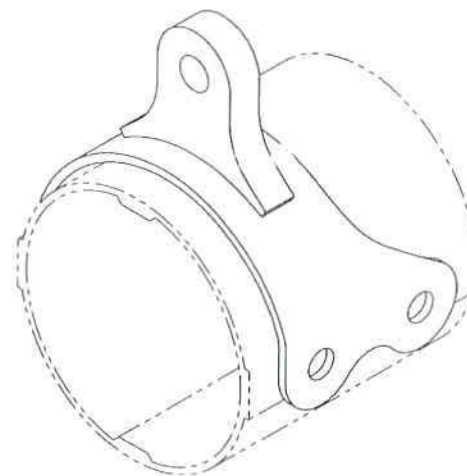
119006

15

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

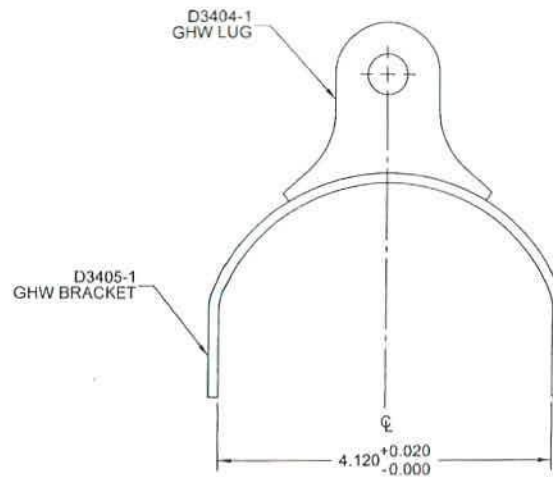
NO. 77686
11/12-16

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01/12/18 M/S

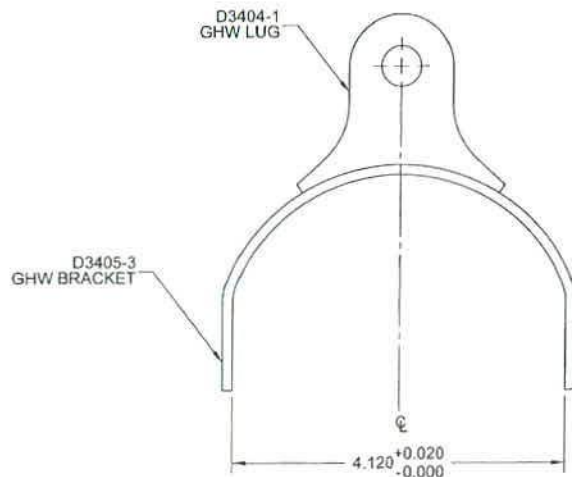
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
; IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

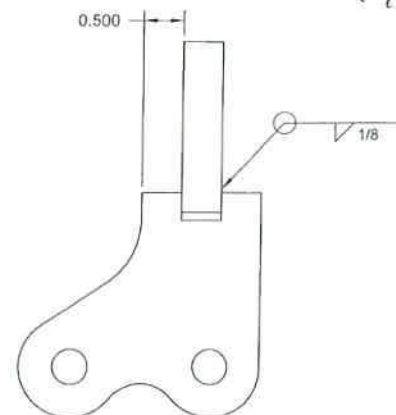
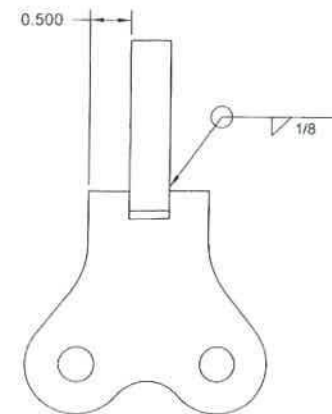
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE AS 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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D3405-041 LUG ASSEMBLY



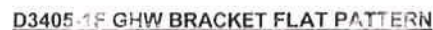
D3405-043 LUG ASSEMBLY



177684

RELEASED
06/12/18

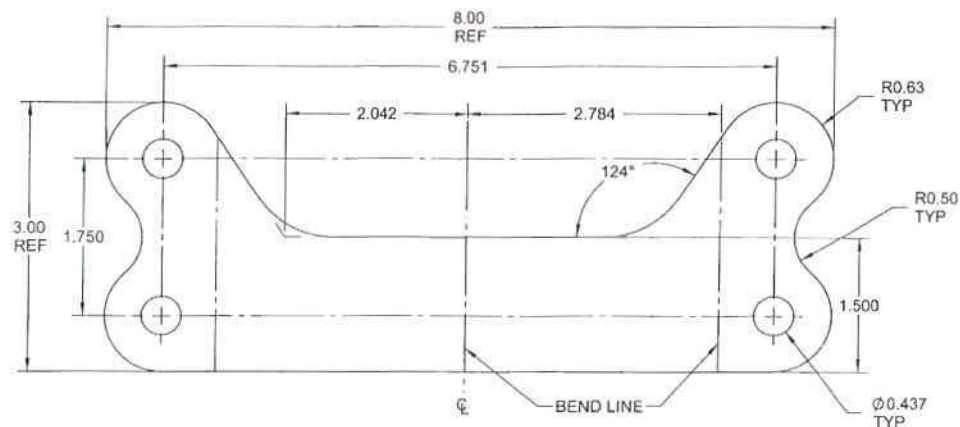
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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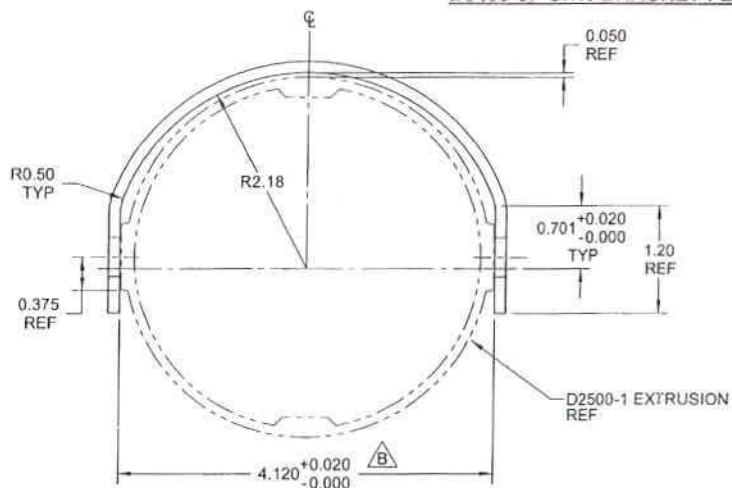
77684

RELEASED
APR 08/12/13

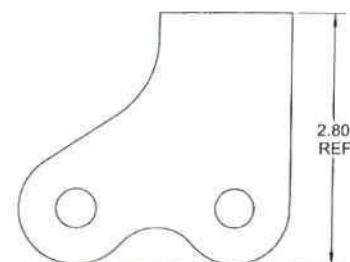
- | | | | |
|------------|---|--|--------------|
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HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. |  | D3405 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | GHW LUG ASSEMBLY | NTS |
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

77484

RELEASED
08/12/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF: DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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